

Date: Wednesday, 13/06/2008 1:27:35 PM
 User: Julie Lécocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WELDMENT TOP PANEL
Job Number : 39933	
Estimate Number : 13029	
P.O. Number :	Part Number : D36503
This Issue : 18/06/2008 S.O. No. :	Drawing Number : D3650 REV.B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 36942	Material :
Written By :	Due Date : 07/07/2008 Qty: 3/2 Um: Each
Checked & Approved By : <u>JUL 08.6.18</u>	
Comment : Est Rev:A New Issue 07-09-27 DD verified by: EC Est Rev:B ECN 1113P 08-01-22 DD Est Rev:C ecn1162 08-04-02 DD verified by: EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S26GA	304/316 0.018 SHEET
-----	-----------	---------------------



3.8



Comment: Qty.: 1.2023 sf(s)/Unit Total : 2.4045 sf(s)

304/316 SS sheet 26 ga (0.018" thick)

Batch: 108415 HB 8-6-26

108415 HB 07-21

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET

1-Cut as per Dwg D3650

Dwg Rev: BProg Rev: BHB 8-6-26

B HB 8-7-21 (7) (6)

2-Deburr if necessary

HB 8-6-26HB 8-7-21

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--

HB 8-6-26HB 8-7-21**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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S 08/07/21 (16)

**Comment:** SECOND CHECKS 08/07/01 (3)

5.0	BRAKE NC	NC BRAKE
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**Comment:** NC BRAKE

Form as per Dwg D3650

PD (17) (5)
 8/6 08/07/23
S 08/07/01 (3)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3650-3 PAR #: ~~4000~~ Fault Category: Prod/Machined NCR: Yes ☒ No ☐ DQA: D Date: 28/05/08
QA: N/C Closed: D Date: 28/05/08

NCR: <u>39933</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/07/10	50	During inspection it was found that the 2.12" from Deep form at 4.1" long is actually 3.875" long.		Parts are accurate as per E-mail between Roberto and Marc Belavene. from July 11 th , 2008	N/A			
		RC tooling has been incorrect since the beginning		open a PAR to Redox tooling to correct length.				
08/07/23	5	1 Part moved under the jig at the bending need better jig.		Scrap - destroy no replace Qty 10 PAR is to be opened problem already know about				

NOTE: Date & initial all entries

RC Parts was used for test first Part.

Date:

Wednesday, 18/06/2008 1:27:35 PM

Julie Lecocq

Process Sheet

Customer: QU-DAR001 Dart Helicopters Services

Drawing Name: WELDMENT TOP PANEL

Job Number: 39933

Part Number: D36503

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



S 08/07/23 (45)



Comment: INSPECT WORK TO CURRENT STEP

S 08/07/14 (42)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

8.0

D365011

Filler Plate



PTD 4

Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

FILLER PLATE

batch B39949 B40694

PD 08-07-28

PD 08-07-15 (5)

9.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: 1-trim to fit

2-Weld assembly as per dwg D3650 QSI004

PD 08-07-29 (5)

PD 08-07-15 (5)

10.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08/07/29 (5)

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/07/29 (45)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and stock

Location: 39926-1

FF 08-07-30 (5)

13.0

QC21

FINAL INSPECTION/W/O RELEASE



(5)

Comment: FINAL INSPECTION/W/O RELEASE

PD 08/05/08

Job Completion



Dart Aerospace Ltd

W/O: 39933		Est # 13029 13029 2		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE				By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
8/7/15	# 9.1	ADD step to grind welds flush after welding -> make QC 10 permanent change. 2				MA	08/07/15		MA	S Schaak

Part No: D3650-3 PAR #: N/A Fault Category: Prod/Small Fab NCR: (Yes) No DQA: D Date: 08/05/15
D3650-041 for 2nd NCR. QA: N/C Closed: D Date: 08/05/15

NCR: 39933		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08-07-15	9	Trim too short D3650-11 R.C. Part has to be trimmed by hand	MA	Scrap D3650-11 Qty (x1) no replace	PD 08-07-15	MA	MA	MA
08/07/15	9.0 9.1	Parts were ground too much, resulting in the material being too thin. High risk of cracking. R.C. did not pay attention to the amount of material being removed, on and around the well.	MA	- material is too thin, and can not be rewelded, or filled. - scrap: replace Qty 3. on this W/O	FF 08/07/15	MA	MA	MA

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 39938
Description: Center Panel		Part Number: D3650-3
Inspection Dwg: D3650	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.221	+0.005/-0.001	0.225	*			
Ø0.213	+0.005/-0.001	0.213	*			
0.40	+/-0.030	0.40	*			
15.45	+/-0.030	15.45	*			
10.49	+/-0.030	10.49	*			
15.53	+/-0.030	15.55	*			
11.99	+/-0.030	12.00	*			
12.90	+/-0.030	12.91	*			
4.300	+/-0.010	4.300	*			
12.09	+/-0.030	12.094	*			
13.06	+/-0.030	13.06	*			
1.943	+/-0.010	1.944	*			
5.884	+/-0.010	5.885	*			
8.248	+/-0.010	8.248	*			
9.196	+/-0.010	9.196	*			
13.80	+/-0.030	13.80	*			
2.28	+/-0.030	2.29	*			
7.19	+/-0.030	7.19	*			
9.55	+/-0.030	9.55	*			
10.65	+/-0.030	10.65	*			
3.35	+/-0.030	3.38	*			

Measured by: HB	Audited by: J	Prototype Approval:	N/A
Date: 8-6-26	Date: 08/07/01	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.04.17	New Issue	KJ/DD	

DART AEROSPACE LTD		Work Order: 39933
Description: CENTER PANEL		Part Number: D3650-3
Inspection Dwg: D3650 Rev: B		Page 1 of 1

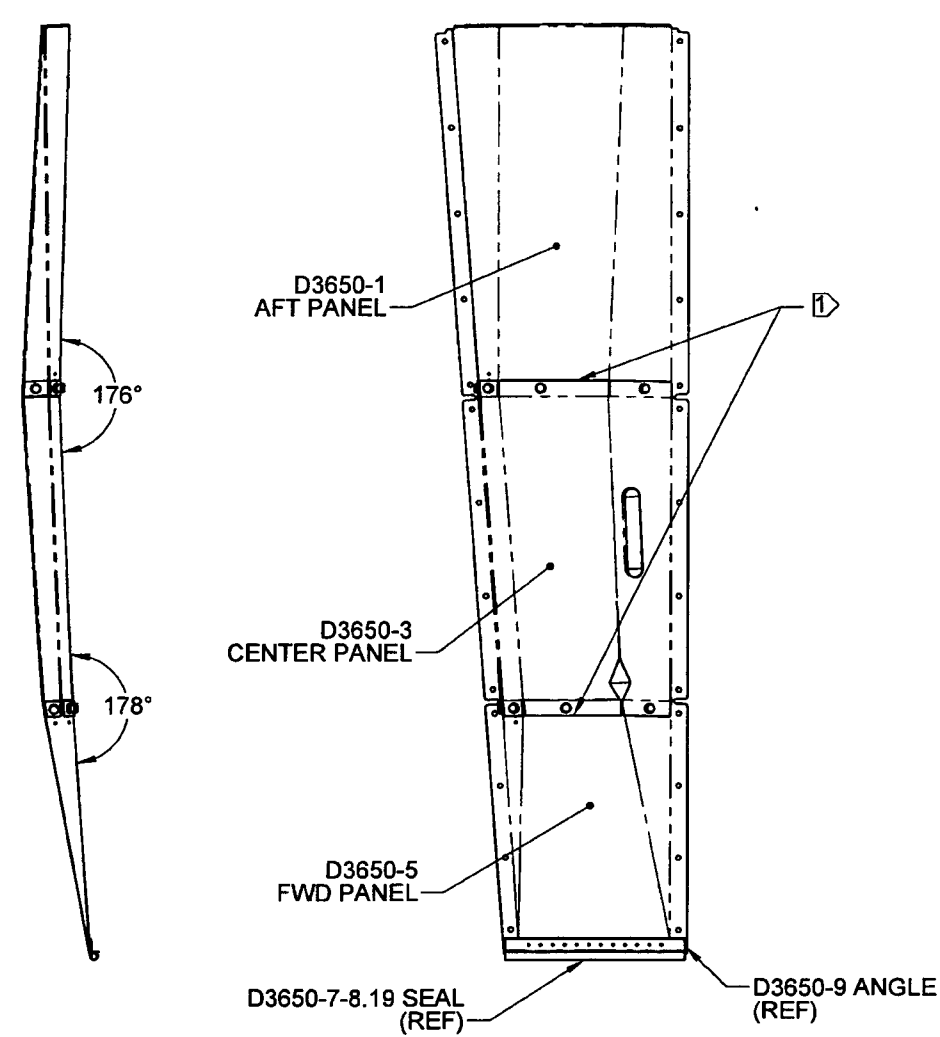
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .221	+0.005 - .001	.2224	*			
Ø .213	+0.005 - .001	.215	*			
.140	±.030	.140	*			
15.45	±.030	15.45	*			
10.49	±.030	10.49	*			
15.53	±.030	15.53	*			
11.99	±.030	11.99	*			
12.90	±.030	12.90	*			
4.300	±.016	4.301	*			
12.09	±.030	12.09	*			
13.06	±.030	13.06	*			
1.943	±.010	1.943	*			
5.884	±.010	5.886	*			
8.248	±.010	8.250	*			
9.196	±.010	9.200	*			
13.80	±.030	13.80	*			
2.28	±.030	2.29	*			
7.19	±.030	7.195	*			
9.55	±.030	9.55	*			
10.65	±.030	10.65	*			
3.35	±.030	3.353	*			

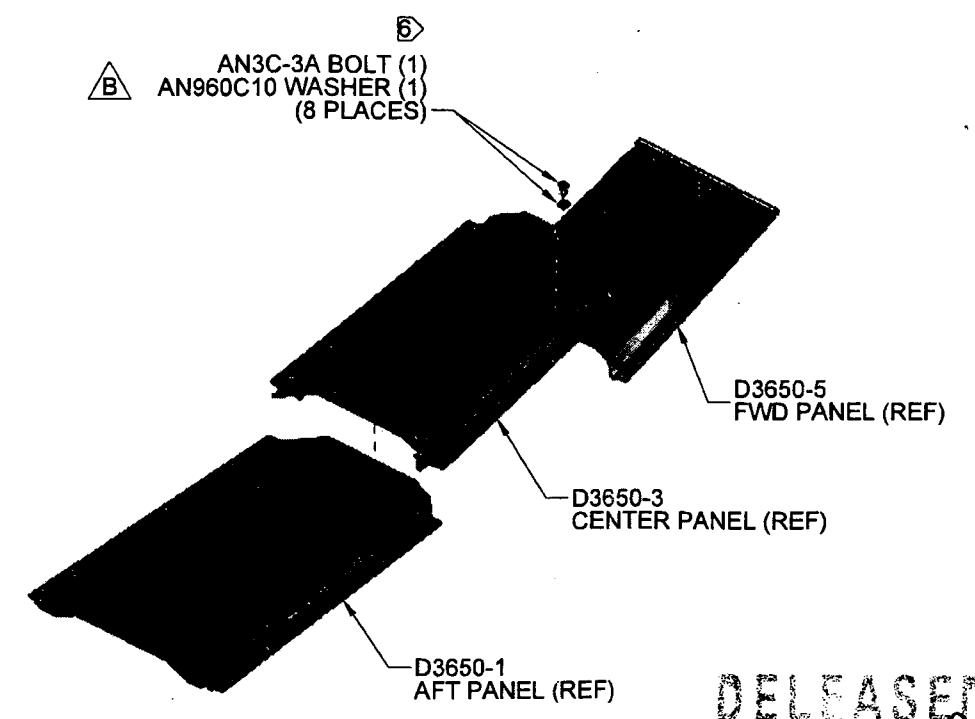
Measured by: EB	Audited by: S	Prototype Approval: n/
Date: 8-7-21	Date: 08/07/21	Date: 7

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



D3650-041 TUNNEL TOP PANEL ASSEMBLY

- NOTES:**
 1) SEAL ALL MATING SURFACES AND ALL GAPS USING PROSEAL 700 FIRE WALL SEALANT
 2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 3) UNITS: INCHES UNLESS OTHERWISE NOTED
 4) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 5) IDENTIFICATION: NONE
 6) TORQUE FASTENERS 15 TO 25 in-lb
 7) WEIGHT: 3.3 lbs

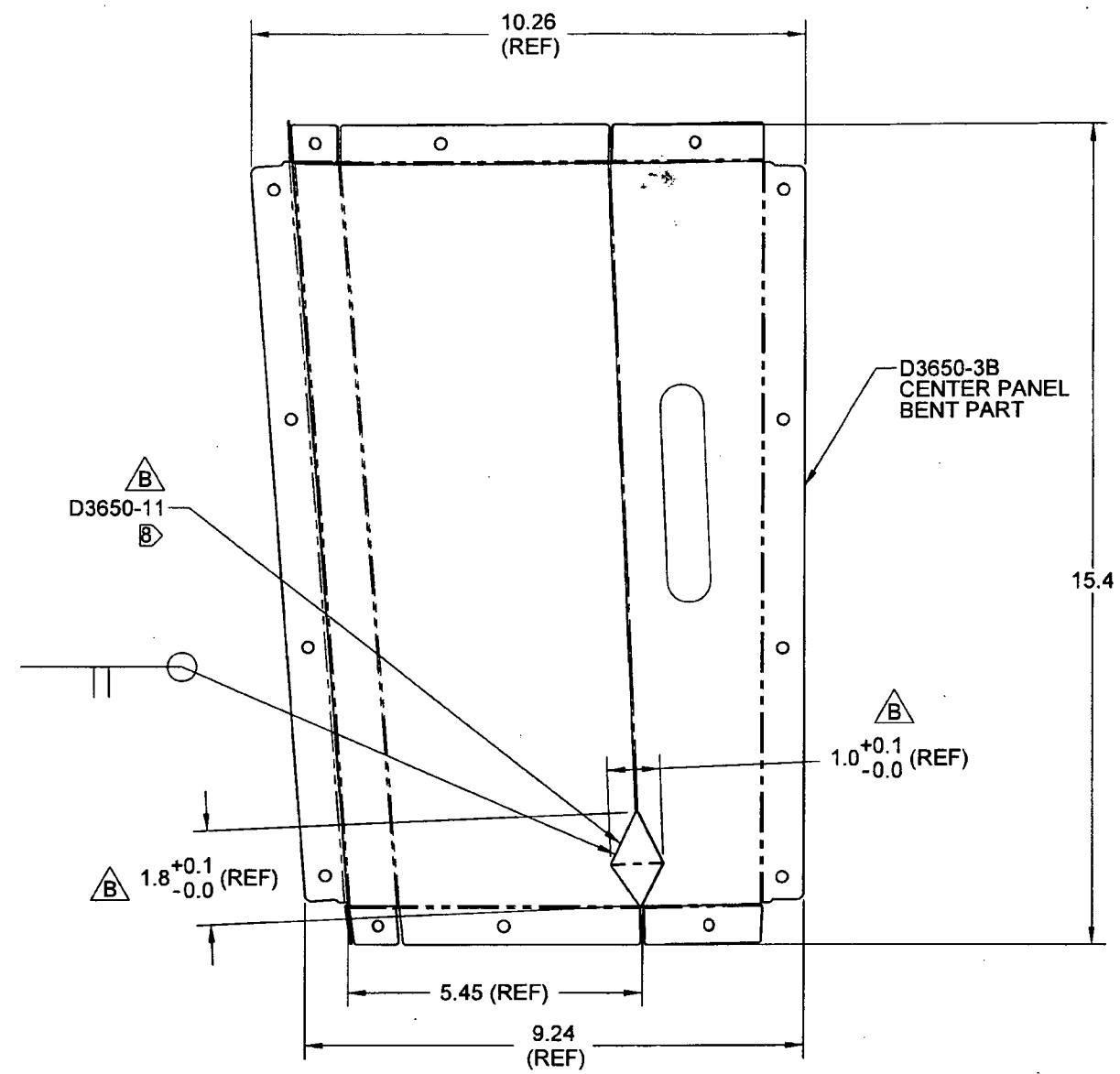


PART LIST

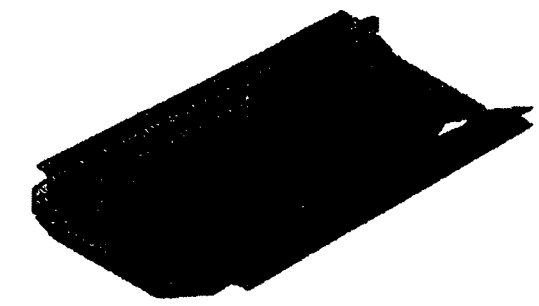
QTY -041	PART NUMBER	DESCRIPTION
X	D3650-041	TUNNEL TOP PANEL ASSEMBLY
1	D3650-1	AFT PANEL
1	D3650-3	CENTER PANEL
1	D3650-5	FWD PANEL
8	AN3C-3A	BOLT
8	AN960C10	WASHER

B	SHEETS 1, 2 & 7: UPDATED FASTENER QUANTITIES; UPDATED VIEWS SHEETS 3 & 8: REMOVED/RELOCATED HOLES; UPDATED VIEWS SHEET 4: 1.8 WAS 1.5; 1.0 WAS 0.8; UPDATED VIEW; ADDED NOTE 8 SHEET 5: REMOVED NOTE IN C6 & ASSOCIATED DIMS; UPDATED VIEWS SHEET 6: REMOVED/RELOCATED HOLES & ADDED CUTOUT TO D3650-3F; MOVED D3650-11/-11F TO SHEET 9; ADDED DETAIL SHEET 9: RELOCATED D3650-11/-11F FROM SHEET 6; UPDATED DIMS OF D3650-11/-11F		RF	08.01.07
	A NEW ISSUE		RF	07.11.07
REV.	DESCRIPTION		BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	RF	DRAWING NO. D3650 REV. 18 SHEET 1 OF 9		
CHECKED	LE	TITLE TOP PANEL ASSEMBLY SCALE 1:8		
MFG. APPR.		DATE 08.01.07		
APPROVED		COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		
DE APPR.				

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D3650-3 CENTER PANEL



PART LIST

QTY	PART NUMBER	DESCRIPTION
-3	D3650-3	CENTER PANEL
1	D3650-3B	CENTER PANEL BENT PART
1	D3650-11	FILLER PLATE

NOTES:

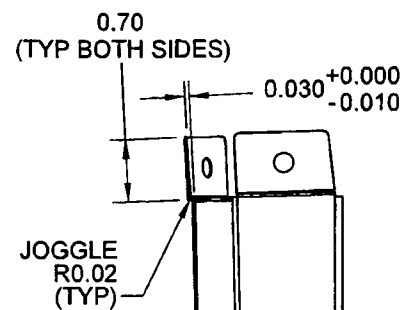
- 1) WELD PER QSI 004
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.0 lb
- 8) TRIM D3650-11 TO FIT AS REQUIRED



DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED	UC	DRAWING NO. D3650
MFG. APPR.		REV. B
APPROVED		SHEET 4 OF 9
DE APPR.		TITLE TOP PANEL ASSEMBLY
DATE	08.01.07	SCALE 1:3
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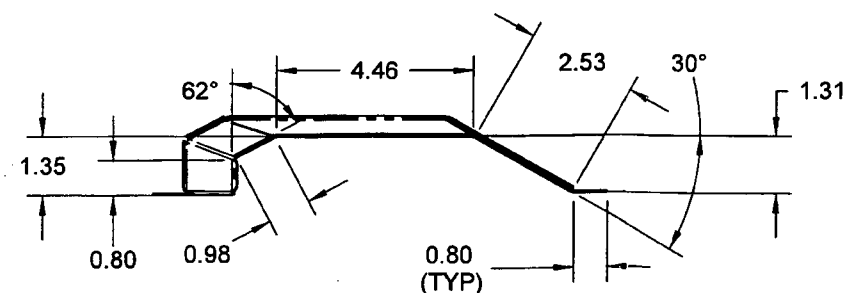
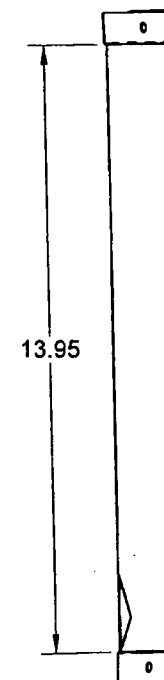
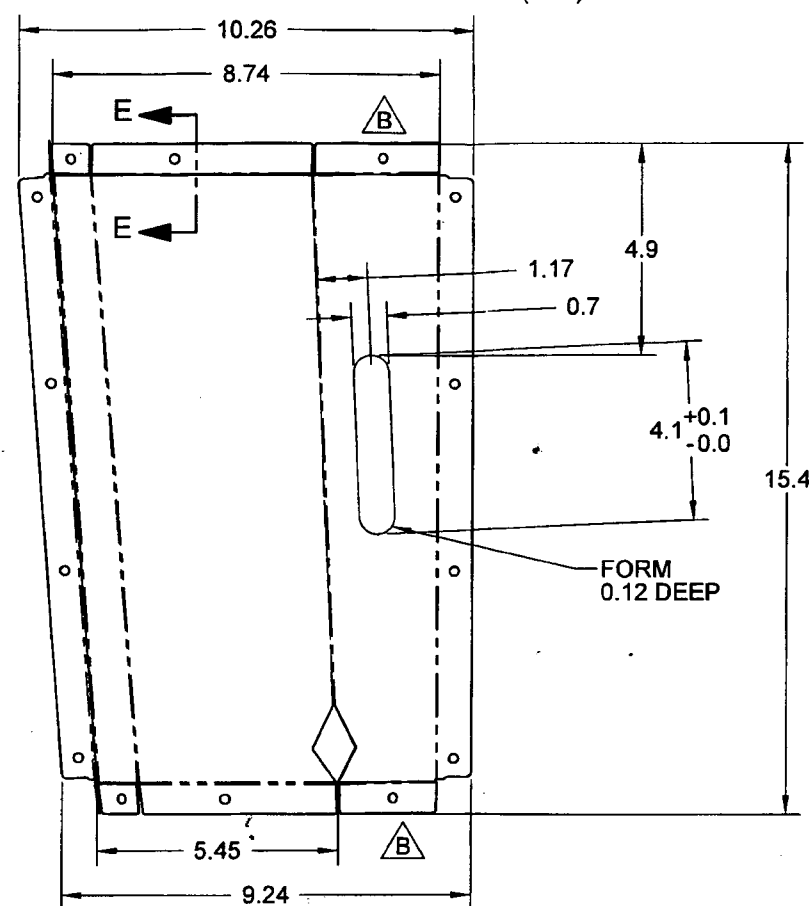
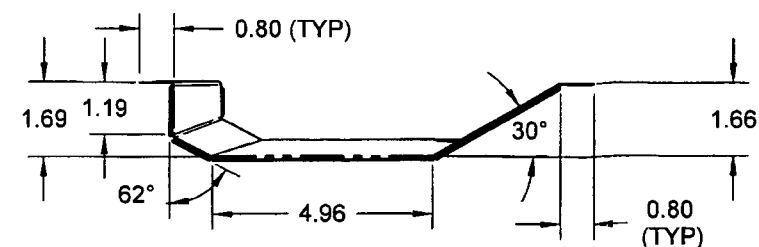
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RELEASED
08-03-27



SECTION E-E

*Awaiting
revised dwg
from E.C.
Robert to see
the PAR.*



NOTES:

- 1) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE

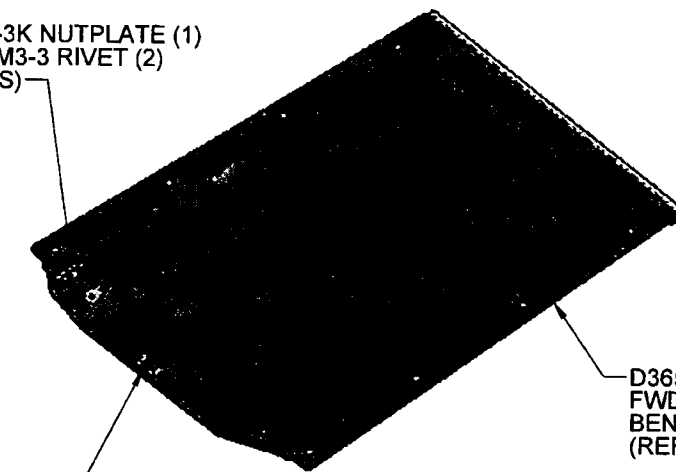
D3650-3B CENTER PANEL BENT PART
(MAKE FROM D3650-3F FLAT PATTERN)

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	UE	DRAWING NO.	REV. B
MFG. APPR.		D3650	SHEET 5 OF 9
APPROVED		TITLE	SCALE
DE APPR.		TOP PANEL ASSEMBLY	1:4
DATE	08.01.07	<small>COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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08-03-27

MS21062-3K NUTPLATE (1)
MS20427M3-3 RIVET (2)
(2 PLACES)



MS21060-3K NUTPLATE (1)
MS20427M3-3 RIVET (2)
(2 PLACES)

B

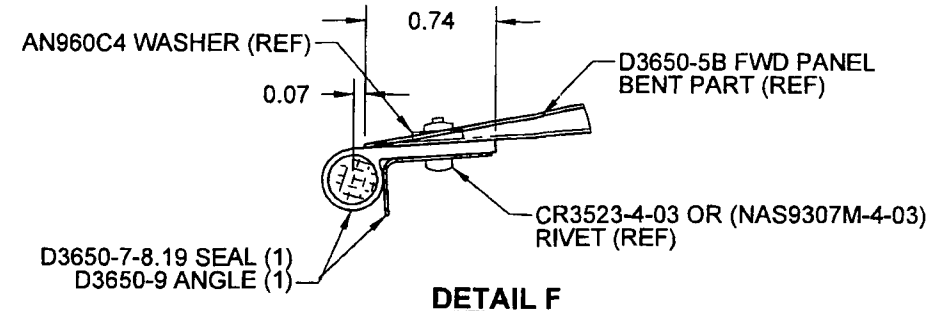
PART LIST

QTY .5	PART NUMBER	DESCRIPTION
X	D3650-5	FWD PANEL
1	D3650-5B	FWD PANEL BENT PART
1	D3650-7-8.19	SEAL
1	D3650-9	ANGLE
12	AN960C4	WASHER
12	CR3523-4-03 or NAS9307M-4-03	RIVET
8	MS20427M3-3	RIVET
2	MS21060-3K	NUTPLATE
2	MS21062-3K	NUTPLATE

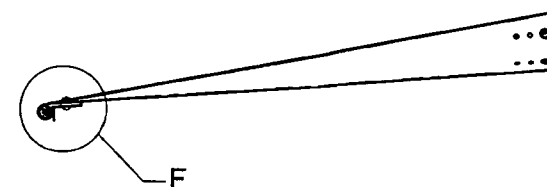
B

NOTES:

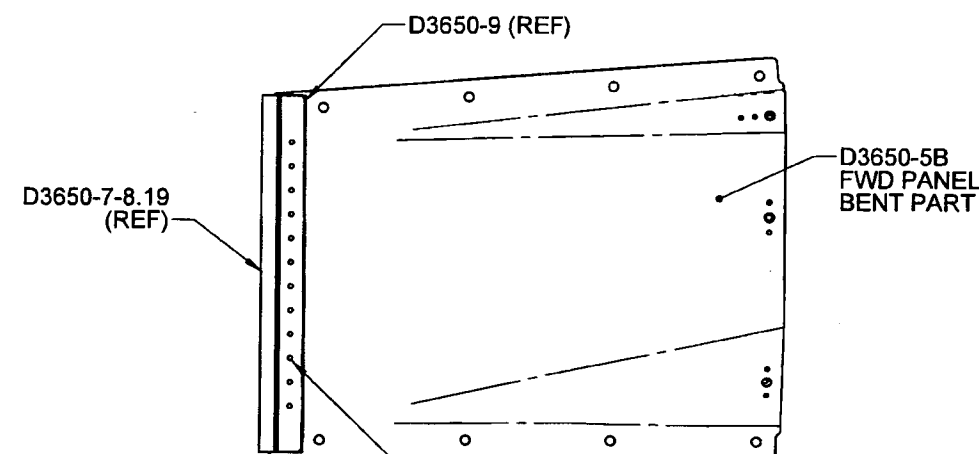
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 THICK (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.8 lbs



DETAIL F

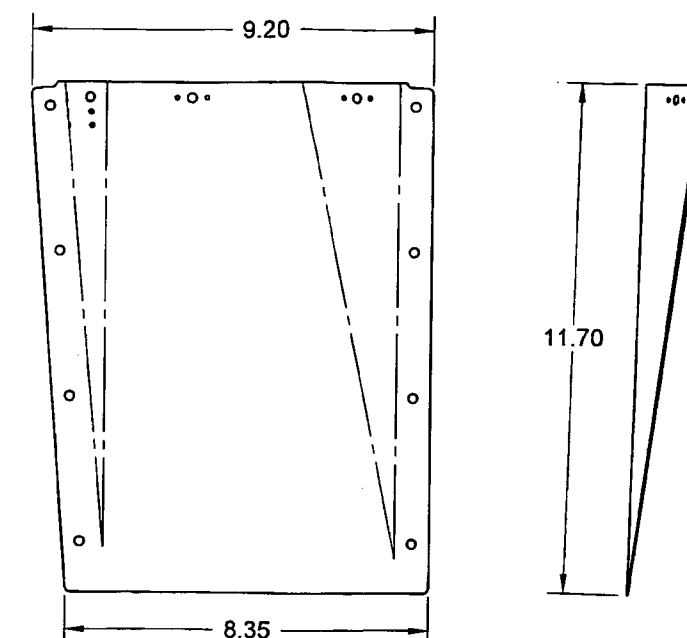
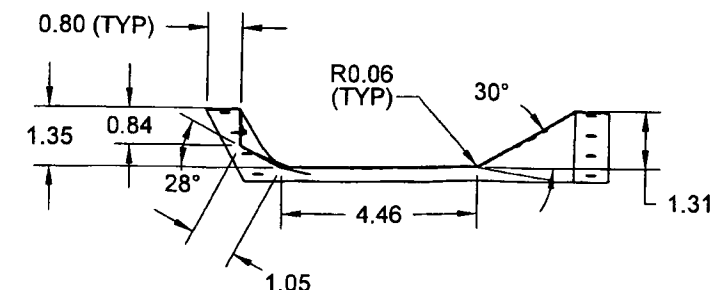


F



CENTRE D3650-7/-9 ON D3650-5B &
TRANSFER $\phi 0.129$ (#30 DRILL) HOLES
FROM D3650-9 TO D3650-7 & D3650-5B
AS SHOWN
INSTALL
CR3523-4-03 OR NAS9307M-4-03 RIVET (1)
AN960C4 WASHER (1)
(12 PLACES)

D3650-5 FWD PANEL

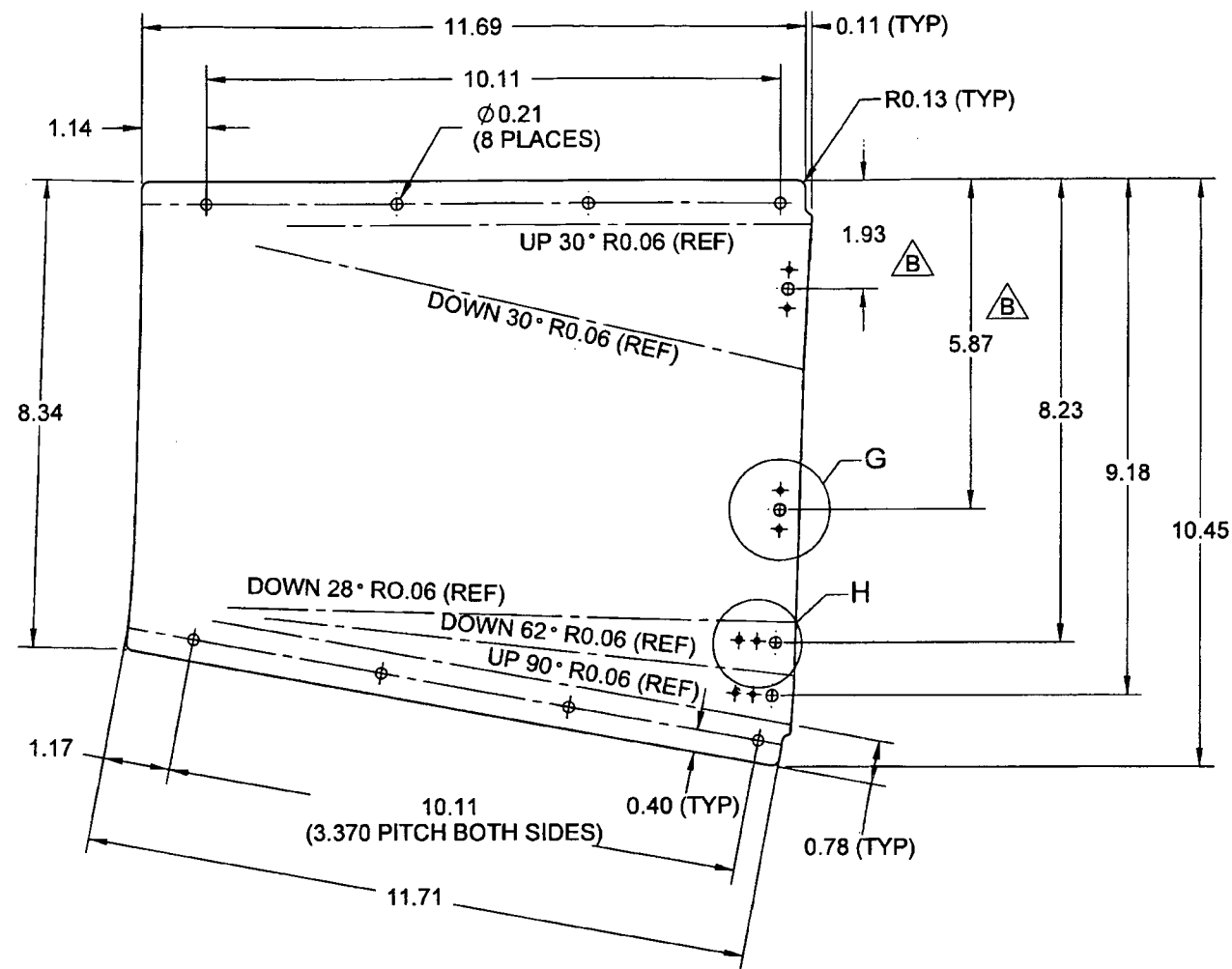


D3650-5B FWD PANEL BENT PART
(MAKE FROM D3650-5F FLAT PATTERN)

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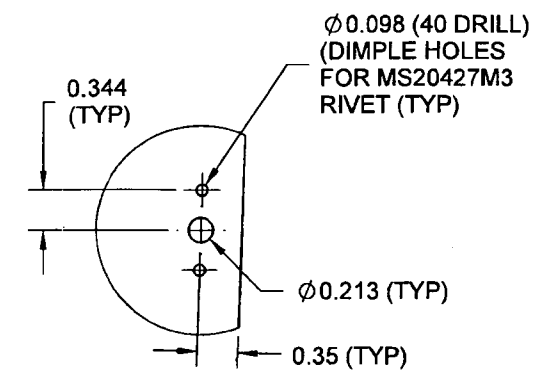
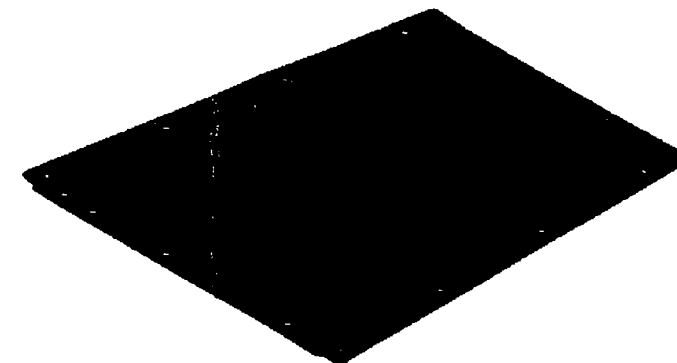
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	LE	DRAWING NO.	REV.
MFG. APPR.	MP	D3650	SHEET 7 OF 9
APPROVED	MP	TITLE	SCALE
DE APPR.	MP	TOP PANEL ASSEMBLY	1
DATE	08.01.07	COPYRIGHT © 2007 BY DART AEROSPACE LTD	
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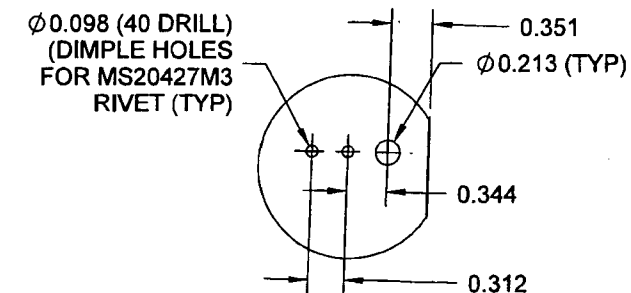
D3650-5F FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 THICK (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.6 lb



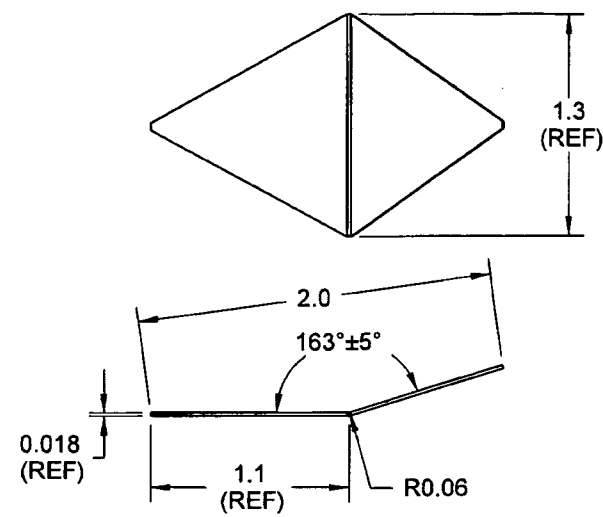
DETAIL G
(2 PLS)



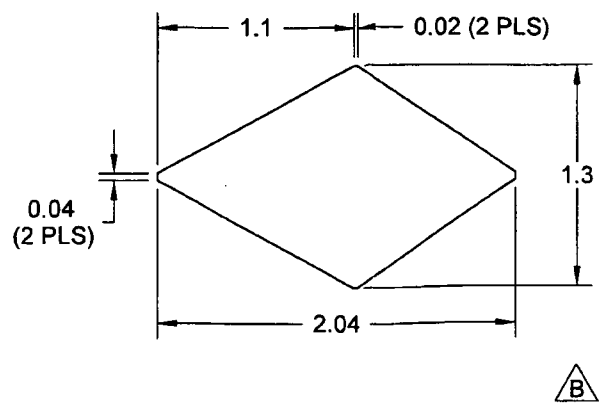
DETAIL H
(2 PLS)

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NO. 38933

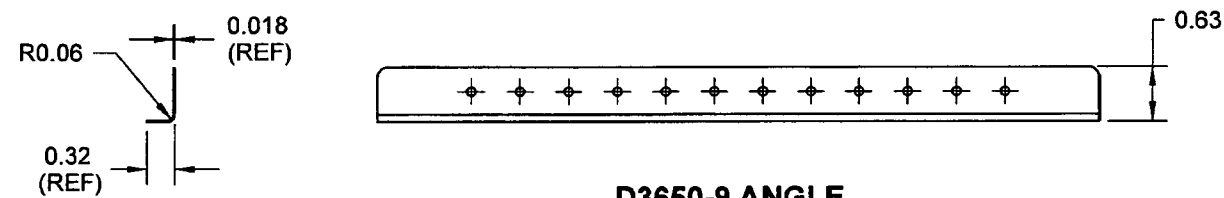
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KE	DRAWING NO.	REV. B
MFG. APPR.	100	D3650	SHEET 8 OF 9
APPROVED	100	TITLE	SCALE
DE APPR.	100	TOP PANEL ASSEMBLY	1:3
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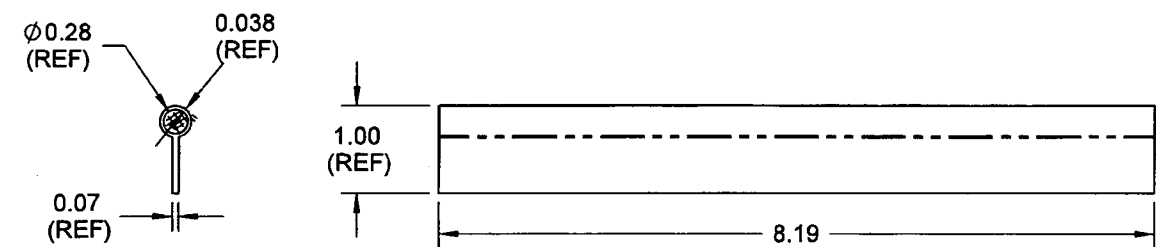
D3650-11 FILLER PLATE
(MAKE FROM D3650-11F FLAT PATTERN)
(SCALE 1:1)



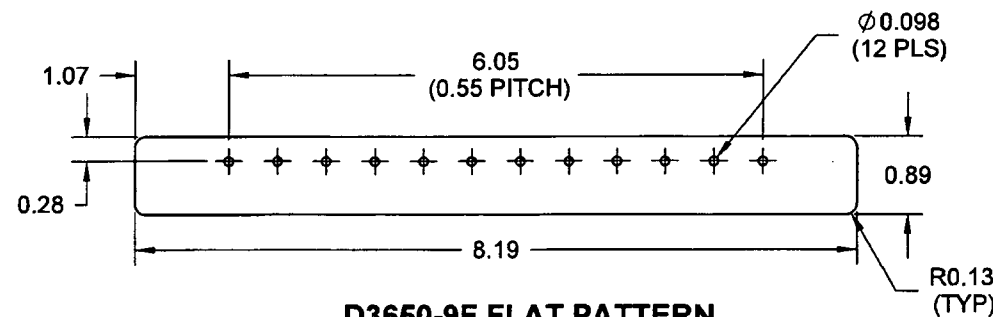
D3650-11F FLAT PATTERN
(SCALE 1:1)



D3650-9 ANGLE
(MAKE FROM D3650-9F FLAT PATTERN)



D3650-7-8.19 SEAL



D3650-9F FLAT PATTERN

- D3650-7-8.19 NOTES:**
 1) MATERIAL: P/N 8168-1 TADPOLE SEAL (REF. BELL P/N 120-104-1)
 POSSIBLE SUPPLIER: EAGLE COPTERS OR BELL
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: NONE
 7) WEIGHT: 0.05 lb
 8) PART NUMBER: D3650-7-X.XX
 WHERE X.XX = LENGTH IN INCHES
 EG. 12.50" LONG = D3650-7-12.50

- D3650-9 & D3650-11 NOTES:**
 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 THICK (26 GAUGE) SHEET,
 PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: NONE
 7) D3650-9 WEIGHT: 0.05 lb
 D3650-11 WEIGHT: 0.007 lb

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	LE	DRAWING NO.	REV. B
MFG. APPR.	MA	D3650	SHEET 9 OF 9
APPROVED	MA	TITLE	SCALE
DE APPR.	MA	TOP PANEL ASSEMBLY	1:2
DATE	08.01.07	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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Marc Bellavance

From: Roberto Fuentes [rfuentes@dartaero.com]
Sent: July 11, 2008 10:03 AM
To: 'Marc Bellavance'
Cc: 'Jason Murdoch'
Subject: RE: D3650-3B Non-Conformance

It is acceptable 3.87" instead of 4.1" for this time. Ensure FAI and tooling need to update to much the 4.1" shown in the D3650 Rev. B drawing.

Roberto

From: Marc Bellavance [mailto:mbellavance@dartaero.com]
Sent: Friday, July 11, 2008 6:29 AM
To: 'Roberto Fuentes'
Cc: 'Jason Murdoch'
Subject: D3650-3B Non-Conformance
Importance: High

Hey Roberto,

How are you today? Hope life is good at your end.

Eric Downing came to see me with a non-conformance on D3650-3B Center Panel Bent Part. The 4.1" +0.1"/-0.0" x 0.12" deep indentation measures 3.87" and is therefore 0.23" under tolerance. It turns out that the indentation was formed per tooling which also measures 3.87".

According to Dan Stow, the previous panels sent out to Eagle for form, fit and function purposes was made from the same tooling. This means that the guys at Eagle installed a D3650-3B with an indentation that is 0.23" under tolerance.

Regardless, the part does not measure up to the drawing. So the question is: is the indentation acceptable at 3.87" instead of 4.1"?

If it is not acceptable, we will have to raise a NCR and have Production manufacture a new tool. If it is acceptable, we will have to revise our drawing.

Thanks Roberto!

Marc Bellavance
Mechanical Designer/Technical Support

DART aerospace Ltd.

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E-mail: mbellavance@dartaero.com
Web: www.dartaero.com

11/07/2008

Marc Bellavance

From: Roberto Fuentes [rfuentes@dartaero.com]
Sent: July 16, 2008 9:00 AM
To: 'Marc Bellavance'
Cc: 'David Duval'; 'Jason Murdoch'; 'Mike Petsche'
Subject: RE: D3650

Yes is required to be grinded flush on the outside surface. May be for this DEO drawing will do.

Thanks Marc,
Roberto

From: Marc Bellavance [mailto:mbellavance@dartaero.com]
Sent: Wednesday, July 16, 2008 6:22 AM
To: 'Roberto Fuentes'
Cc: 'David Duval'; 'Jason Murdoch'; 'Mike Petsche'
Subject: D3650

Roberto,

On D3650 drawing, P/N D3650-11 gets welded to D3650-3 Center Panel.
We know that the weld bead must be grinded flush to D3650-3 but this is not indicated on the drawing.

Can you reply to this email and give your okay to grind the weld flush?
Maybe we can update the W/O (or Estimate) and eventually update the drawing.

Thanks Roberto!

Marc Bellavance
Mechanical Designer/Technical Support

DART aerospace Ltd.

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